Work Orde July-12-13 10:30		582				Page 1						
Revision ID: Item Name:		Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*	Accept	*N900 Cust Item I Customer:		 10()*	Setup	Start	IV.	S1* S2*
Reference:			. .				_		Run	Start		
Approvals:	Process Plan:	MLJ	Date: 13-07-16	Tooling:	Da	ite:			XuII	Stop	*N	R1*
	QC :	-· <u> </u>	_ Date:	SPC (Y/N):	U Da	ite:				Stop	*N	R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
Draw Nbr	. Revisi	ion Nbr										,
D3246	Rev A	1					<u>.</u>	- 				
*100 *100* Waterjet FLOW CNC Waterje 7024 · 050	et	FLOW WATER JET Memo 1-Cut as pe Deburt if no		0.00 0.00 Prog Rev:	<u> </u>			_ 4	<u> </u>	<u>o</u>		_Ae_ 13.08.1
*110 *11 0 *	(QC2- Inspect parts off r	machine FAI/FAIB	0.00				ل	r	A		\mathcal{A}_{c}
QC Quality Control		Memo		0.00						<u> </u>		13.08.12
120 *120*		QC8- Inspect parts - sec	cond check	0.00 27	12			4				
QC		Мето		0.00 / 3, 8	ر،						*	

Quality Control

DQA:			Date:			– "λΔRT									
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI	PDATE	W	ork Order ug	odate only	7	AEROSPACE
						DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS		
Work Orde	er:									Adamsi	_		- 1100233	_	
						Rework			Skid-tube	Crosstube			Water Jet	_	Engineering
Part N	lo.					Scrap		1	Machining	Small Fab	\vdash	1	d. Eng. Coor.	_	Quality
						Use-as-is			oforming	Finishing		Rec/Sto	e/Packaging	_	Other
NCR 1	۱o.					Suspected Unapproved			Large Fab	Composite	L	ļ	Supplier		
Root		_			Desc	ription of work order update		Initial	Act	ion		Sign &		\neg	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification		QC Inspector
Design											-				
Doc/Data			ŀ											-	
Equip/Tooling			}												
Handling/Pre]											
Material					ŀ										
Operator							1								
Offset/Setup			1												
Process															
Supplier							ĺ							- }	
Training		!												-	
Transport					1										
Unapproved						<u> </u>	<u> </u>					<u> </u>	<u></u>		
							FA	ULT CAT	EGORY						
Landi	ng (Gear				General	_	1			_	1	_		
	$oxed{oxed}$	Bending			<u> </u>	Bend	L	4	rogram			Outside Dim	. -	_	Pressure/Forced
	_	Centre N	ot Concer	ntric		BOM/Route	<u> </u>	Grain			<u>_</u>	Over/Under	-		Set-up
	_	Cracks			<u> </u>	Broken/Damage/Defect	_	Hardwa			\vdash	Part incorre	 	_	Temperature/Cure
		•	nk/Ripple	/Wave	_	Burrs		-1 `	on Incomplete/Ur		<u></u>	Part Lost/M	ssing	_	Weld
	\vdash	Cuffs			<u> </u>	Contamination	<u></u>	-ł	ions Incomplete/l	Jnclear	\vdash	Part Moved	L	\	Wrong Stock Pulled
	Ŀ	Crushing			<u> </u>	Countersink	_		ned/off center		\vdash	Positioned V		_	
	<u> </u>	Heat Trea			<u> </u>	Cut Too Short	\vdash	Mislabe			L	Power Loss/	Surge		Other
	_	Inspectio		Tube	\vdash	Drawing	-	Misread	I						
!						Off-set									
	_	1	Sequence			Finish	\vdash	-	Calibration						
1	l	Wave/Tw	vist in Tub	e e	1	Fit/Function	1	Out of 9	equence				_		

Work Ord <i>July-12-13 10:</i>		4582		*1045			Page 2					
Item ID: Revision ID: Item Name:	D3246-041 Bracket	· . <u></u>		Accept	*N900		100)*	Setup Sta	1.7	S1* S2*	
Start Date: Required Date Reference:	7/12/13 : 7/12/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item II Customer:	D:						
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):	 .	te:			Run Sta	171	R1* R2*	
Sequence ID/ Work Center I 130 *120* Brake NC Brake NC	D	Operation Description NC BRAKE Memo DeburrFore	n as per Dwg D3246C'sink	Set Up/ Run Hours 0.00 0.00 as per Dwg D3246	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	- 75731
*140 *140* QC Quality Control		QC5- Inspect part comp	eleteness to step on W/O	0.00 SWN 0.00 B. 9. S)			<u>y_</u>				

150

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

150 HandFinish

Finish

0.00

Hand Finishing

4 26,13.9.5

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DQA:		_ Date:		WORK ORDER NON-CONFORMANCE / UPDATE							TOART	
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UPD/		ork Order up	date only	AEROSPACE
Work Orde		-			DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
WORK OF GE	er.				Rework	1		Skid-tube C	rosstube	7	Water Jet	Engineering
Part N	lo	·			Scrap Use-as-is			Machining S	Small Fab Finishing		d. Eng. Coor.	Quality Other
NCR N	No				Suspected Unapproved]		Large Fab Co	omposite]	Supplier	
Root				Desc	ription of work order update		nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description	on	Date	Verification	QC Inspector
Design					•							
Doc/Data												
Equip/Tooling												
Handling/Pre		İ			i							
Material						1						
Operator												
Offset/Setup												
Process		1	1			ŀ						
Supplier												
Training												
Transport												·
Unapproved												
						FA	ULT CA	regory				
Landi	ng Gear				General	_	_			_		_
:	Bendin	g			Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
:	Centre	Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	ire '		Part Incorred	t	Temperature/Cure
	Crimp/I	Kink/Ripple	e/Wave		Burrs	L	Inspect	ion Incomplete/Unqua	ılified	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/Uncle	ear	Part Moved		Wrong Stock Pulled
	· Crushin	g			Countersink		Misalig	ned/off center		Positioned V	vrong	_
	Heat Tr	eat			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
Inspection Strip in Tube Dray		Drawing		Misread	t							
	Marks/	Chatter			Drill Holes		Off-set					
	Turning	Sequence)		Finish	Out of Calibration						
			Fit/Function		Dutofe	Secuence						

 Work Ord July-12-13 10:3		4582		*104	1582*				·· <u> </u>		Page 3
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	D3246-041 Bracket 7/12/13 7/12/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*	Accept	*N900 Cust Item II Customer:		100		Stop	*NS2) *
Approvals:	Process Pla	on:	Date:	Tooling: _ SPC (Y/N):		nte:		F	Run Star Stop	"NR	
Sequence ID/ Work Center I 160 *160* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Ins Number Sta	
170 *170* Small Fab Small Fab		Small Fab Memo Install Nut F	Plates as per Dwg D324	0.00 0.00 6		·		4x	· —- —		S3/09/

180

Small Fab

QC5-Inspect part completeness to step on W/O

DAS **27** 9-89

120 Quality Control

Memo

0.00 13-9-6

DQA:			Date:			_								TO A C
OA Classic			Data			WORK ORDER NON-	ON-CONFORMANCE / UPDATE Work Order update only						AEROSPACE	
QA Closed:			Date:			r		-		VV	ork Order up	odate only		
Work Orde	r:					DISPOSITION			AG	AINST DE	PARTMENT,	/PROCESS		
	-					Rework		•	Skid-tube Cros	sstube		Water Jet		Engineering
Part N	o.					Scrap			—	all Fab	Pro	d. Eng. Coor.		Quality
	-			•		Use-as-is		Thern	noforming Fin	nishing		re/Packaging		Other
NCR N	lo.					Suspected Unapproved			Large Fab Com	posite		Supplier		
Root					Desc	ription of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	!	ief Eng	Description		Date	Verificatio	n	QC Inspector
Design			·						<u> </u>					
Doc/Data		;	1 1										į	
Equip/Tooling														
Handling/Pre		!				I								
Material														
Operator														
Offset/Setup]											
Process			1											
Supplier														
Training					İ									
Transport			1		1									
Unapproved														
							FA	ULT CAT	TEGORY					_
Landin	ng G	ear			_	General		-			1		_	1
1		Bending			<u> </u>	Bend	_	1	rogram	ļ	Outside Dim		-	Pressure/Forced
	_	Centre No	ot Concer	itric	\vdash	BOM/Route	_	Grain		_	Over/Under	tolerance	L	Set-up
		Cracks			<u> </u>	Broken/Damage/Defect	_	Hardwa			Part Incorred		L	Temperature/Cure
[]	\dashv	Crimp/Kir	ık/Ripple,	/Wave	<u> </u>	Burrs	<u>_</u>	1	ion Incomplete/Unqualifie		Part Lost/Mi	ssing	<u> </u>	Weld
	_	Cuffs			\vdash	Contamination	<u></u>	-1	ions Incomplete/Unclear	_	Part Moved		L	Wrong Stock Pulled
	-	Crushing			<u> </u>	Countersink		-	ned/off center		Positioned V	-	_	Ī
]		Heat Trea			<u> </u>	Cut Too Short	L	Mislabe		<u>_</u>	Power Loss/	Surge	L	Other
1 -	_	Inspection		Tube	\vdash	Drawing	_	Misread	i					
]	\neg	Marks/Ch			<u> </u>	Drill Holes	L	Off-set						
]	$\overline{}$	Turning 5			_	Finish	<u>_</u>	4	Calibration					
	_	Wave/Tw	ist in Tub	e		Fit/Function]	Out of 9	Sequence					

104582

Page 4

July-12-13 10:30:06 AM

Item ID:	D3246-041		A	accept	*N900	040	100	<u> </u>	Setup Stai	" *N	S1*
Revision ID: Item Name:	Bracket								Sto	^p *N	S2*
Start Date: Required Date: Reference:	7/12/13 7/12/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:					
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):		ate:		ì	Run Sta Sto		IR1* IR2*
Sequence ID/ Work Center II 190 *100* Packaging Packaging	D	Operation Description Identify as per dwg & Si	tock Location: 570.35	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty $\mathcal{H}\chi$	Reject Qty	Reject Number	
200 *200* QC Ouality Control		QC21- Final Inspection Memo	- Work Order Release	0.00					12/0	1/99	<u>}</u>

RB-09-9

DQA:	_		Date:	-		WORK ORDER NON-CONFORMANCE / UPDATE							
QA Closed:			Date:			WORK ORDER NON-	-00	JNFOR	CIVIAINCE / UP		Vork Order up	odate only	AEROSPACE
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part N	- No				_	Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	_	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	Т				Desc	ription of work order update		nitial	Acti	ion	Sign &		T
Cause	ļ	Date	Step	Qty		or non-conformance		ief Eng	Descri		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved			8										
							FA	ULT CAT	TEGORY				
Landi		Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspectio Marks/Ch	nk/Ripple at n Strip in natter	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/Un ions Incomplete/U ned/off center led	<u> </u>	Outside Dim Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	tolerance ct issing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
						Fit/Function	Out of Sequence						

Picklist Print

July-12-13 10:30:05 AM

Work Order ID:

104582

Parent Item:

D3246-041

Parent Item Name:

Bracket

Start Date: 7/12/13

Required Date: 7/12/13

Page 1

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty	Qty Issued	Date Issued	Status
M2024T3S.050 2024-T3 .050 sheet		Purchased	No			170	sf	175.1920	0.3097	1.304		/	de 13.0
				Location		Loc Oty	Lo	oc Code					
				MAT022		175,192							
					643_	175.192			12	4643		1	/
MS20426AD3-3 RIVET		Purchased	No			170	Each	6,346.0000	8		Di	3/09	66_
KIVE.		,		<u>Location</u>		Loc Oty	<u>L</u> c	oc Code			/	77	
				ST316		699							
					109	282							
				190	99	417							
				ST333		5647							
					011	29							
					814 352	120 5498			_3	2	0		11
MS21059L3 Nut Plate		Purchased	No			110	Each	269.0000	4	16		13/1	19/06
Trut Truto				Location		Loc Qty	La	oc Code					275
				ST316		225				/			
					291	7						~ ('	75
				125	535	218					MI	260	<i>_</i> ,

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124308

ST506

DQA:		-	Date:			WORK ORDER NON-CONFORMANCE / UPDATE							
QA Closed:			Date:			WORK ORDER NON-	-00	INFO	RIVIAINCE / OF		ork Order up	odate only	AEROSPACE
West Ost						DISPOSITION		· - · · ·		AGAINST DE	PARTMENT	/PROCESS	
Work Orde	er: -				'	Downerly	,		المطبيع لمنياء	Crasstuba	7	Water Jet	Engineering
Down h	1				i	Rework		ı	Skid-tube Machining	Crosstube Small Fab	Pro	d. Eng. Coor.	Quality
Part N	10.				_	Scrap Use-as-is	!		noforming	Finishing	4	re/Packaging	Other
NCR N	J۵					Suspected Unapproved	1	HICKH	Large Fab	Composite	1 1100,310.	Supplier	⊣
, , ,	•••					Suspected Shapproved	,		20.80 . 22		_}		
Root		-	-		Desc	ription of work order update	lr	nitial	Acti	on	Sign &		
Cause		Date	Step	Qty		or non-conformance	Chi	ief Eng	Descri	iption _	Date	Verification	QC Inspector
Design								•		-			
Doc/Data							ļ		ľ		1		
Equip/Tooling									ļ !				
Handling/Pre													
Material			,										
Operator											•		
Offset/Setup													
Process													İ
Supplier	Ш												
Training.	Щ		ļ										
Transport	$\mid \rightarrow \mid$												
Unapproved			<u> </u>		Ĺ <u>.</u>						<u> </u>	<u> </u>	<u></u>
<u> </u>							FAL	JLI CA	TEGORY				
Landi	_					General		ee/c		<u> </u>	Outside Dim	: Г	Pressure/Forced
	Н	Bending			-	Bend DOM/Reves	\vdash		Program	F	4	 -	Set-up
	\vdash	Centre No	ot Concer	ntric	-	BOM/Route	┢┯┥	Grain		-	Over/Under Part Incorre	-	Temperature/Cure
	Н	Cracks	-1./p:1.	f) 4 f	-	Broken/Damage/Defect	—	Hardwa		auglified	⊣	-	Weld
	Н	Crimp/Ki	пк/кірріе	wave	-	Burrs	\vdash		ion Incomplete/Un tions Incomplete/U	} —	Part Lost/Mi	12211.B	Wrong Stock Pulled
	-	Cuffs			\vdash	Countersials	\vdash		•	miclear –	Positioned V	L Vrong	Wrong Stock Palled
	\vdash	Crushing	••		-	Countersink Cut Too Short	\vdash	Mislabe	gned/off center	<u> </u>	Power Loss/		Other
	⊢⊣	Heat Trea		Tubo	-	-	\vdash	Misrea		<u></u>	Thomas rossy	201RE	Other
	_	Inspectio		rube	-	Drawing Drill Holes	\vdash	Off-set					
						Finish	Out of Calibration						
[Wave/Twist in Tube				-1		Seguence			· · · · · · · · · · · · · · · · · · ·			

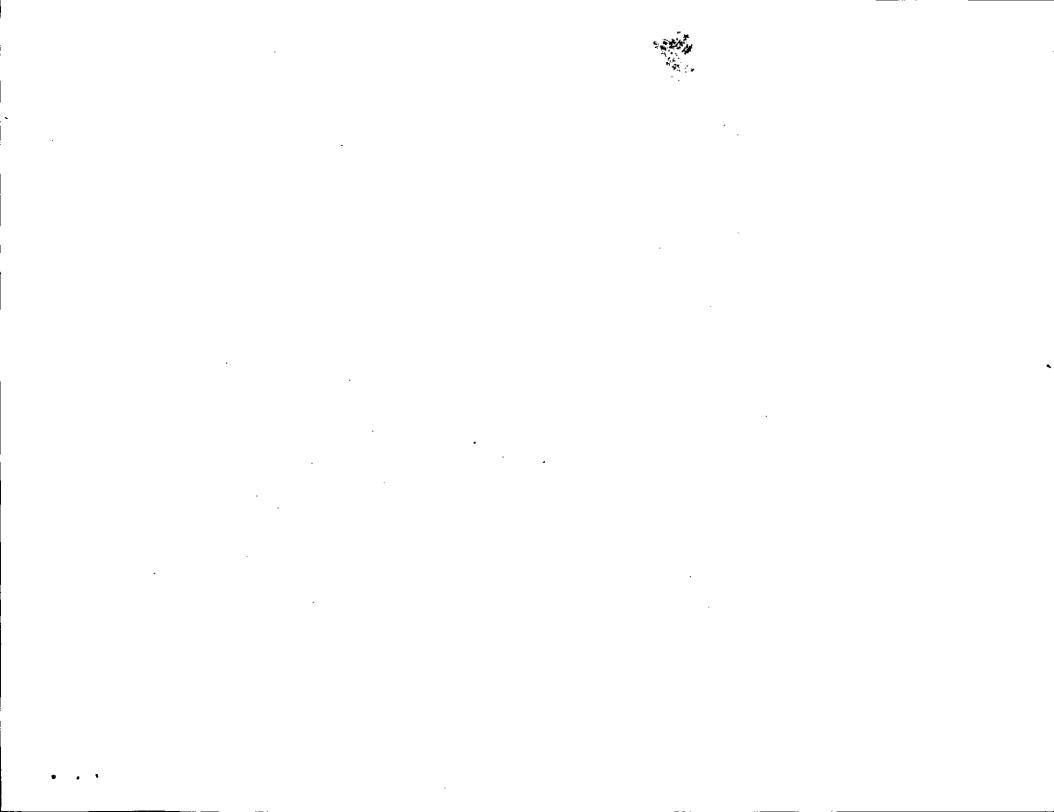
DART AEROSPACE LTD	Work Order:	104587
Description: Mounting Bracket	Part Number:	D3246-1
Inspection Dwg: D3246 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x	First Article	Prototype
للنا		

		First Article Pro			rototype			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments	
Ø0.098	+0.004/-0.001	.98	1		V	JKM	- 01	
Ø0.250	+0.005/-0.001	,250	1		٧		<u> </u>	
11.260	+/-0.010	11.260			T	JKM	- 0 G	
6.754	+/-0.010	6754	-		V	G 7-11-		
5.677	+/-0.010	5.677	1		V			
2.668	+/-0.010	2.668	1		V			
3.467	+/-0.010	3,467	_		v	_		
2.750	+/-0.010	2.750	-	1	V			
2.370	+/-0.010	2.370	_		V			
0.472	+/-0.010	.472	,		V			
0.359	+/-0.010	.359	_		V		,	
0.300	+/-0.010	360	-		V			
0.301	+/-0.010	,30)			V			
Date: 15	3.08,12	Audited by:	27 3 F L	P	<u> </u>	Date:	N/A N/A	
	Change	DIO D0046 044			Revise	d by	Approv	

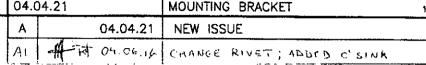
Rev	Date	Change		Revised by Appr	oved
Α	07.11.23	New Issue	P/O D3246-041	KJ/EC/DD -X/L	



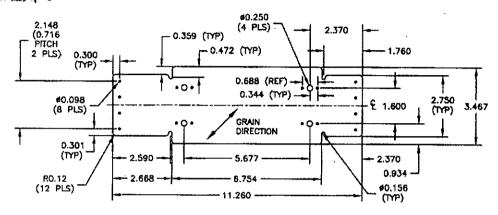




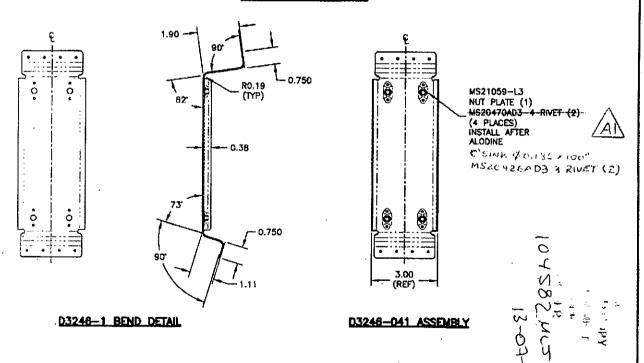
	DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
ľ	CHECKED	APPROVED CHI	DRAWING NO. D3246	REV. A SHEET 1 OF 1			
I	DATE		TITLE	SCALE			
	04.04.21		MOUNTING BRACKET	1:4			
I	Α	04.04.21	NEW ISSUE				



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D3246-1 FLAT PATTERN



NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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